

S263940



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246



D5805-5
Job Sheet 208156



POSITIVE RECALL

EFFECTIVE 3/13/20 AUTH MDE

RELEASED _____ DATE _____

Part No: D5805-5

Job Qty: 12 pcs

Part Name: Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/12/20

Job Tracking No:

Due Date: 3/24/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 20-522 DWG D5805 REV.A IPP REV:A NEW ISSUE 20.01.15 JV VERF:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs	3/24/20	3/24/20	0.17	0.60	Waterjet - Flow		<u>20/03/13</u>
							Waterjet - Omax		
110	QC 2	12 pcs	3/24/20	3/24/20	0.00	0.00	QC 2 - 1		<u>20/03/13</u>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

120	QC 8	12 pcs	3/24/20	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Packaging 3-1 - Stock - B4B	12 pcs	3/24/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	

MAR 17 2020 40
9:59

WFL

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	045
140 QC 21 - SA	12 pcs	3/24/20	0.00 0.00	QC 21 - SA - 21	045
				QC 21 - SA - 70	045
				QC 21 - SA - 53	045

Part Op 100 - 1-Cut as per DWG D5805-5. DWG. Rev: A PROG. Rev: A 2-Debur if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

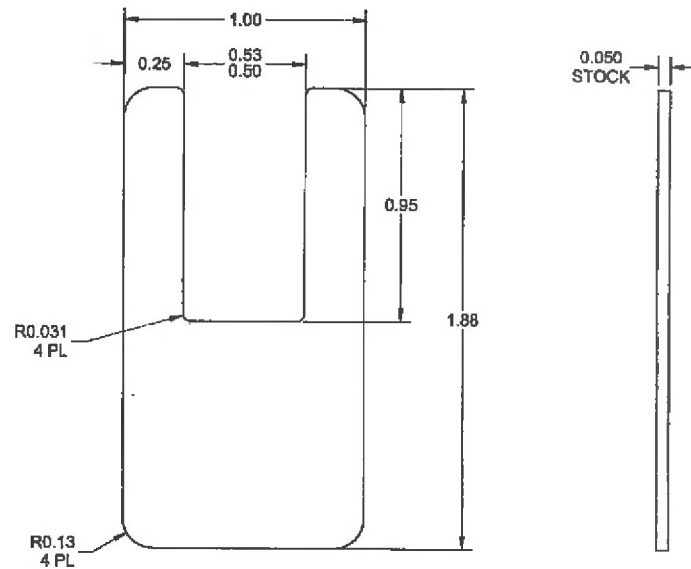
MAR 17 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M1010S18GA	1010/1025 Sheet .048	.1812 sf (.0151 ea)	100-Waterjet - Flow - 1	FM137041-1

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M1010S18GA	0	84	0

Part Specifications	
Specifications could not be found.	

Plex 3/12/20 9:18 AM Dart.lajeunesse.marie



D5805-5 CAP
(DERIVED FROM AERO DESIGN P/N 70423-04)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 208156 MLW
20-08-12

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: AISI 1010/1025 STEEL SHEET, COLD ROLLED, #18 GA (0.050 THICK)
PER ASTM A36/A368/A1008 OR CSA G40-21 36W/44W/50W/60W/70W
REF DART SPEC M1010-S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
2020 FEB 18 *MD*

APPROVED

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5805 TITLE ATTACHMENT HOOP COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE ON THE OPEN MARKET PLACE. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV. A
DRAWN	ZF		SHEET 6 OF 6
CHECKED	KPT		SCALE
MFG. APPR.	DD		NTS
APPROVED	NO		
DE APPR.	CP <i>MD</i>		
DATE	20.01.13		

Purchase Order Receipt Listing

Monday, March 13, 2017 8:40:22 AM

Page 1 of 2

All amounts are calculated in domestic currency.

All Vendors PO ID PO35495 Receipt Dates from 3/10/2017 to 3/10/2017 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
Vendor ID/Vendor Name VC-CAM002 Acier OneBette Inc.											
PO35495	1		M1010918GA	sf	3/10/2017	3/10/2017	32.0000	\$1.13	0.0000	0	\$36.14
CAD	No		1010/025 SHEET	sf	32.0000	PLOU01		\$36.14	0.0000	0	
			048								
			m137041								
	2		M2024T3S.040	sf	3/10/2017	3/10/2017	48.0000	\$4.03	0.0000	0	\$193.51
	No		2024-T3 .040 sheet	sf	48.0000	PLOU01		\$193.51	0.0000	0	
			m137041								
	3		M303R0.750	f	3/10/2017	3/10/2017	12.0000	\$3.26	0.0000	0	\$39.08
	No		703 Round Bar 0.750	f	12.0000	PLOU01		\$39.08	0.0000	0	
			m137041								
	4		M304S20GA	sf	3/10/2017	3/10/2017	64.0000	\$2.94	0.0000	0	\$188.36
	No		304/316 .040 Sheet	sf	64.0000	PLOU01		\$188.36	0.0000	0	
			m137041								
	5		M6061T6S.063	sf	3/10/2017	3/10/2017	64.0000	\$2.35	0.0000	0	\$150.22
	No		6061-T6 .063 Sheet	sf	64.0000	PLOU01		\$150.22	0.0000	0	
			m137041								
	6		M6061T6S.188	sf	3/10/2017	3/10/2017	32.0000	\$7.40	0.0000	0	\$236.76
	No		6061-T6 .188 Sheet	sf	32.0000	PLOU01		\$236.76	0.0000	0	
			m137041								
	7		M7075T73R1.000	f	3/10/2017	3/10/2017	12.0000	\$6.59	0.0000	0	\$79.07
	No		7075-T73 Rd Bar 1.00 f	f	12.0000	PLOU01		\$79.07	0.0000	0	
			m137041								
	8		71550-15	Each	3/10/2017	3/10/2017	1.0000	\$35.29	0.0000	0	\$35.29
	No		TUBE HSS 3 X 3 X		1.0000	PLOU01		\$35.29	0.0000	0	
			0.188" (8 FT)								
			m137041								
	9		71550-15	Each	3/10/2017	3/10/2017	1.0000	\$271.08	0.0000	0	\$271.08
	No		6061-T6 BAR 2-1/2"		1.0000	PLOU01		\$271.08	0.0000	0	
			X 6" (5 FT)								
			m137041								

**ACIER OUELLETTE INC.**

935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

Order - Sales**Copy**

C000018604

Customer N° CLI0001056
Date 2017/03/06
Delivery date 2017/03/10
Your order N° 35495
Processed by Josianne Bourdon
Salesman
Carrier OUELLETTE VALLEYFIELD
Credit Terme NET 30
Page 1

Billed to

DART AEROSPACE LTD
1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

DART AEROSPACE LTD
, Ontario,

Att: CHANTAL LAVOIE Tél.: 613-632-5200

Delivery Route 5

Product Description	Weight	Qty	U/M	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 CR SHEET 18G (4 X 8) FECR-18G48 3280 1 X 4' X 8' HEAT: 162A03655	64.00	32.00	PI2_\$CLB	1.00							
2 ALU SHEET .040 (18G) 2024-T3 4B (4 X 12) FEAL-0404122024B 3118 1 X 4' X 12' HEAT: 187B4388	27.02	48.00	PI2_\$CLB	1.00							
3 ROUND SS 304 303 (12R) RSS-34303-12 5760 1 X 12' R/C HEAT: W4B3	18.02	12.00	PI1_\$CLB	1.00							
4 SHEET SS 20G SS304-2B (4 X 8) PESS-20G483042B 3430 2 X 4' X 8' HEAT: 825678	100.48	64.00	PI2_\$CLB	2.00							

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 1010SS-A
 DATE: 17/02/16

PO / BATCH NO.: P-038475 / 1324

MATERIAL CERT REC'D: 1010
 QUANTITY RECEIVED: 32
 QUANTITY INSPECTED: 32
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 0.040
 THICKNESS RECEIVED: 0.040
 SHEET SIZE ORDERED: 48"
 SHEET SIZE RECEIVED: 48"

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y N	
CORRECT FINISH	Y N	
CORROSION	Y N	
CORRECT GRAIN DIRECTION	Y N	
CORRECT MATERIAL	Y N	CP 1010
CORRECT THICKNESS	Y N	0.040
PHOTO REQUIRED	Y N	
CORRECT MATERIAL	Y N	AIN A100
CORRECT REF # TO LINK CERT	Y N	Head # 100000000
CORRECT MATERIAL IDENTIFICATION	Y N	1010SS-A
CORRECT M# ON THE MATERIAL	Y N	113004
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

Testers located in the Quality Office

QC 10 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>48</u>	SIGNED OFF BY: _____
DATE: <u>17/02/16</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



“首钢”牌产品质量证明书
QUALITY CERTIFICATE OF “SHOUGANG” BRAND

营销中心地址: 中国北京市石景山区
 ADD. OF SHOWING GROUP: SHIJINGSHAN DISTRICT, BEIJING, CHINA
 邮政编码 POST CODE: 100041
 电话TEL: (+86)10 68281603
 电邮地址E-MAIL: SSGS@MAIL.SJSHONGMAI.COM.CN
 生产厂地址: 中国河北省邯郸市南营乡刘工业园区 051300
 ADD. OF MANUFACTURER: CAOPUJIAN INDUSTRY PARK, TANGSHAN,
 HEBEI, P.R. CHINA 051300

製造廠：青島鐵鋼聯合有限公司
MANUFACTURER: QINGANG GROUP; QINGANG-JIOTANG UNITED IRON & STEEL CO., LTD.

订货单位 CUSTOMER	中国中远海运工程公司					合同号 CONTRACT NO.		0000090730-0000290801582400				许可证号 LICENSE NO.														
收货单位 PURCHASER	中外运(昆山)物流有限公司					交货状态 CONDITION OF SUPPLY		逐箱检				证明书编号 CERTIFICATE NO.		Z10098203780												
产品名称 PRODUCT	散装 Coal-Coking Ship					发货日期 DATE OF DELIVERY		2018-02-27 10:05:49				证书号 RECORD NO.		SB-08-01A												
标准 SPECIFICATION	ASTM A 1008/A 1008M-12Z15					钢号 STEEL GRADE		CS Type B				页号 PAGE NO.		片1 页, 第1 页												
炉批号 COIL NO.	炉次号 HEAT NO.	表面 S.G.	尺寸 Size (MM)		件数 PCS.	重量 WGT. TON	化学成分: CHEMICAL COMPOSITION %										性能 MECHANICAL PROPERTIES									
			厚度 THK.	宽度 WIDTH			C	Si	Mn	P	S	Al	Ti	Nb	N	屈服强度 Y.S. MPa	抗拉强度 T.S. MPa	伸长率 Elongation %	A50mm	DB	HRC	冲击功 Joules	冲击能 Joules	BH (N/mm ²)		
18B220425020	182A03855	FB	1.12	1219	1	12.130	300	1	20	10	0	40	12	10	29	203		41.6								
18B2204250310	182A03855	FB	1.12	1219	1	12.500	300	1	20	10	0	40	12	10	29	203		<1.0								
以下空白:		None	Below	Empty																						
总计 TOTAL					2	24.630																				
NOTE REMARKS: 发单(票)号: 黄BL9655																										
1. 本产品已按上述要求进行检测合格。其检测结果符合要求，特此声明。 WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN IS PRODUCED AND TESTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE MATERIAL SPECIFICATION. 2. 本质量保证书中所有项目均不作为交付条件。THE BLACK ITEM(S) SHALL NOT BE REGARDED AS DELIVERY CONDITIONS. 3. 质量所保留。THE QUALITY CERTIFICATE WILL COME INTO FORCE WITH A VALID STAMP. 日期 Date: 2018-03-27																										
质检 CHECK																										
质保人和签字人 Person in Charge of Quality Inspection																										
日期																										
张志明																										

C 650 306
C 650 315

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					